

# Work Order ID 61741

September 1, 2010 10:26:41 AM

Page 1

Item ID: D350-589-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Side Door Assembly RH

Start Date: 9/01/10 Start Qty: 1.00

Cust Item ID:

Required Date: 9/10/10 Req'd Qty: 1.00

Customer:

Reference: RA110049

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2991	D								
IIN-D350-589	E								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D350-589-042 CHG005

103

0.00



Small Fab

Memo

0.00

Small Fab

-INSTALL TO EXTRA LATCH TO ENSURE IT SITS FLUSH  
REWORK DOOR IN ACCORDANCE WITH DSI 9463-011

-REPLACE D2992-1 DOUBLERS ON D2991-2 DOOR, PER DRWG

-RE-WORK & FILL HOLES DRILLED BY CUSTOMER PER QSI037  
RECORD MATERIALS USED FOR THIS PROCEDURE

*Setup  
rework for \$100*

<b>DART</b> Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY, ON, CANADA K6A 1K7				TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D350-589-042	CHG	CHG005		
DESC.	Side Door Assembly, RH	STC	SH92-41		
LOT	B47622	STC	SH1012NE		
MODEL	AS350/355	STC			
MADE IN CANADA					

192

855

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-589-042 PAR #: \_\_\_\_\_ Fault Category: Small Feb. NCR ☒ Yes No DQA: \_\_\_\_\_ Date: 10/12/13  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: \_\_\_\_\_ Date: 10/12/14

NCR: <u>61741</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10-12-13</u>	<u>103</u>	<u>cost to rework + perform OSI too much, too costly &amp; not worth continuing. Re-process.</u>	<u>Le</u> <u>10-12-13</u> <u>D350-589-042</u>	<u>Scrap door</u> <u>All holes drilled by customer</u> <u>OSI &amp; rework by customer</u> <u>replaced onto the re-work.</u>	<u>Le</u> <u>10-12-13</u>	<u>10-12-13</u>	<u>Le</u> <u>10-12-13</u>	<u>10-12-13</u>

NOTE: Date & initial all entries

**Work Order ID 61741**

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Page 2

Item ID: D350-589-042

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Revision ID:

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Start Date: 9/01/10 Start Qty: 1.00

Required Date: 9/10/10 Req'd Qty: 1.00

Reference: RA110049

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

105

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

110

Spray Painting per QSI005 4.2

0.00



SprayPaint

Memo

0.00

Spray Painting

REPAINT OUTSIDE OF DOOR WHITE IMRON PER QSI 005  
REFINISH & REPRIME INSIDE OF DOOR

Primer Batch: \_\_\_\_\_

Paint Batch: \_\_\_\_\_

120

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

**Work Order ID 61741**

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Page 3

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly RH

Start Date: 9/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/10/10 Req'd Qty: 1.00



Customer:

Reference: RA110049

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg D2991 & IIN D350-589 and install label as per dwg								
150		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
160		0.00							
	Pick Kit								
Packaging	Memo	0.00							
Packaging	ENSURE ORIGINAL KIT GETS PACKAGED WITH DOOR.								

**Work Order ID 61741**

September 1, 2010 10:26:43 AM



Page 4

Item ID: D350-589-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Side Door Assembly RH

Start Date: 9/01/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/10/10 Req'd Qty: 1.00



Customer:

Reference: RA110049

Run Start



Approvals: Process Plan: Date:

Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

180

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-589-042  
Location: \_\_\_\_\_  
PPP rev: \_\_\_\_\_

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

MF  
10-12-13

# Picklist Print

September 1, 2010 10:26:40 AM

Work Order ID: 61741



Parent Item: D350-589-042



Parent Item Name: Side Door Assembly RH

Start Date: 9/01/10

Required Date: 9/10/10

Comments: IPP rev. A 06.02.16 new issue (was done on D350-589-041) EC  
 IPP Rev:B 08-02-20 ECN1096 DD verified by: EC  
 IPP rev C 08.06.26 revised pick list per QC comments (w/o25886) EC  
 verified : DD IPP rev:D 10.04.29 revise bom

Start Qty: 1.00

Required Qty: 1.00

D2992-1 Manufactured No

Each 23.0000 2.0000



Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST032

23

46789

10

47743

4

58333

9

D350-589-042 Manufactured No

Each 3.0000 1.0000



Side Door Assembly RH

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

3

46680

1

56807

1

58271

1

ORIGINAL B/N47622 CHG005  
 RA110049

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-589 REV. E  
AND  
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-589 REV. 1  
REF CANADIAN STC: SH92-41  
REF FAA STC: SH1012NE

D35X-589-041/-042/-043 Side Door Assembly kits at CHG 004 have an additional latch on the trailing edge to provide better fit and security. The side door kits at CHG 004 should be installed per IIN-D350-589 Rev. E, except a total of (4) D2237 striker plates are now installed. The parts list is updated as follows:

ADD:

Qty -041	Qty -042	Qty -043	Part Number	Description
X			D350-589-041	SIDE DOOR ASSEMBLY, LH AS 350
	X		D350-589-042	SIDE DOOR ASSEMBLY, RH AS 350/355
		X	D355-589-043	SIDE DOOR ASSEMBLY, LH AS 355
1	1	1	D2237	Striker Plate
1	1	1	D2585	Latch Clamp
1	1	1	D2586	Latch
1	1	1	D2621	Latch Plate
1	1	1	AN960JD10	Washer
2	2	2	MS20470AD4-5	Rivet
1	1	1	MS21042L3	Nut (or MS21042-3)
1	1	1	MS27039-1-15	Screw

The DSI-9463-011 kit is available for customers with earlier model D35X-589-041/-042/-043 doors to add an additional latch on the trailing edge of the door.

Qty -011	Part Number	Description
X	DSI-9463-011	DOOR LATCH KIT
1	D2237	Striker Plate
1	D2464-1700	Seal
1	D2585	Latch Clamp
1	D2586	Latch
1	D2621	Latch Plate
1	AN960JD10	Washer
2	MS20470AD4-5	Rivet
1	MS21042L3	Nut (or MS21042-3)
1	MS27039-1-15	Screw
2 SQ. FT	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 09.05.26  
CERT. NO.: SH92-41  
ISSUE NO.: 8

A	NEW ISSUE	CP	09.05.26
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MFG. APPR.	<i>[Signature]</i>	DSI 9463	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SIDE DOOR MODIFICATION	NTS
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**To install the DSI-9463-011 Door Latch Kit:**

- 1) Remove the D35X-589-041/-042/-043 door from the aircraft. Remove the D2464-1700 Seal as required to access the composite structure.
- 2) Trim foam core of door 11.0" (280mm) above the aft door latch as shown in Figure 2 of this service instruction. Bevel foam at 45°.
- 3) Apply (2) layers of 9 oz cloth covering the trimmed area, as shown in Section A-A of this service instruction. Acceptable materials for the composite modification are specified in section 7.0 of QSI 037. Cure at room temperature for 24 hours.
- 4) Temporarily locate the D2621 Latch Plate as shown in Figure 3 of this service instruction. Use latch plate as a template and trace the inner rectangle. Cut a hole through the door skin using the traced rectangle to fit a D2586 Latch. Deburr edges of hole and seal edges with potting resin.
- 5) Touch-up the paint finish with one coat of MIL-P-23377 or MIL-P-23377 primer and 2-3 coats of MIL-C-85285 polyurethane paint to match original finish.
- 6) Install D2621 Latch Plate, D2585 Latch Clamp, D2586 Latch, and associated fasteners in accordance with Figure 52-4 of ICA-D350-589.
- 7) Reinstall the door on the aircraft using existing hardware.
- 8) Locate and install a D2237 Striker Plate opposite the new latch location per Figure 52-4 of ICA-D350-589.
- 9) Install the D2464-1700 Seal around the outside edge of the door as shown in Figure 52-4 of ICA-D350-589.
- 10) Check the doors and latches for proper operation by opening and closing the door. Adjust latches as required.







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DAO # 01-O-01

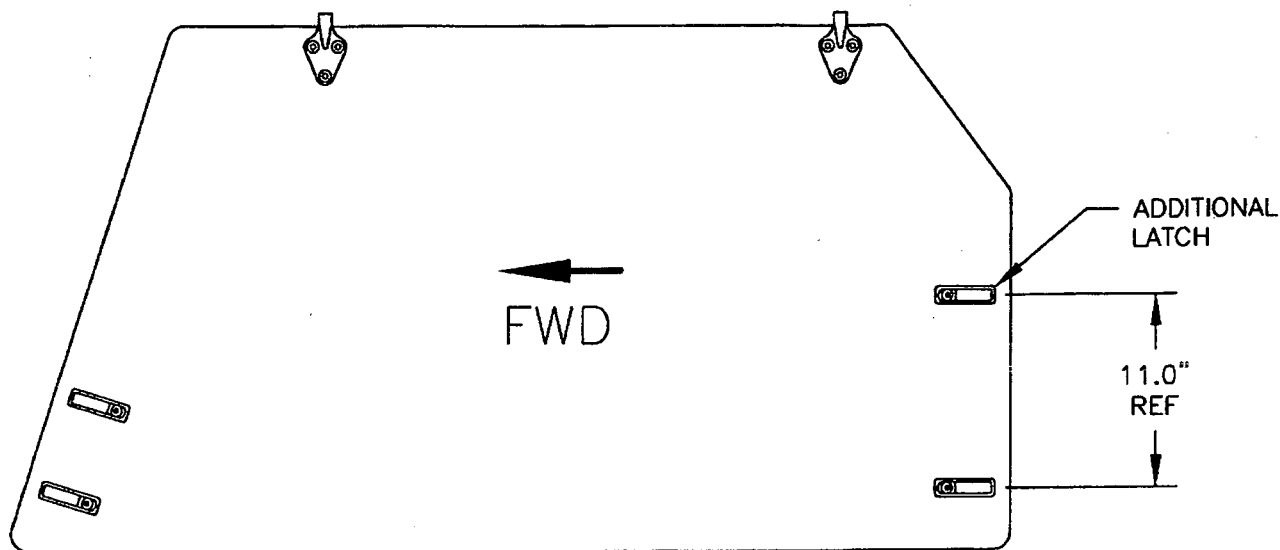
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




**FIGURE 1: D350-589-041 DOOR ASSEMBLY (SHOWN)  
D35X-589-042/-043 (SIMILAR)**

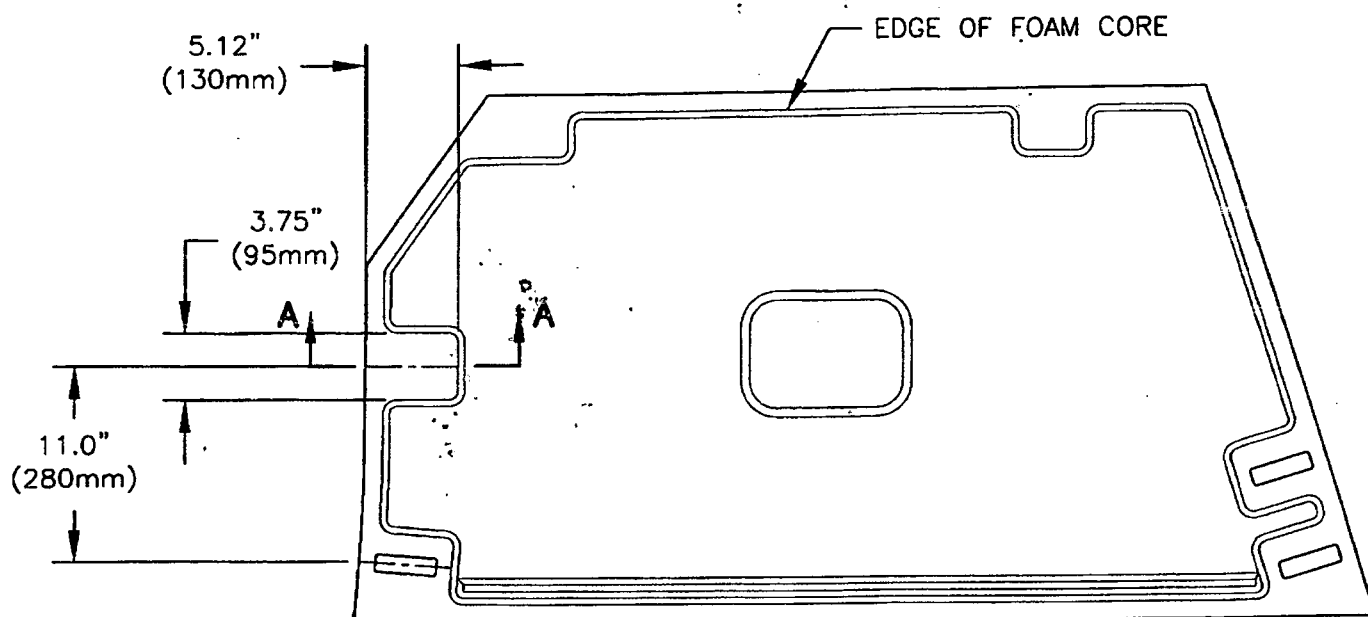
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DAO # 01-O-01

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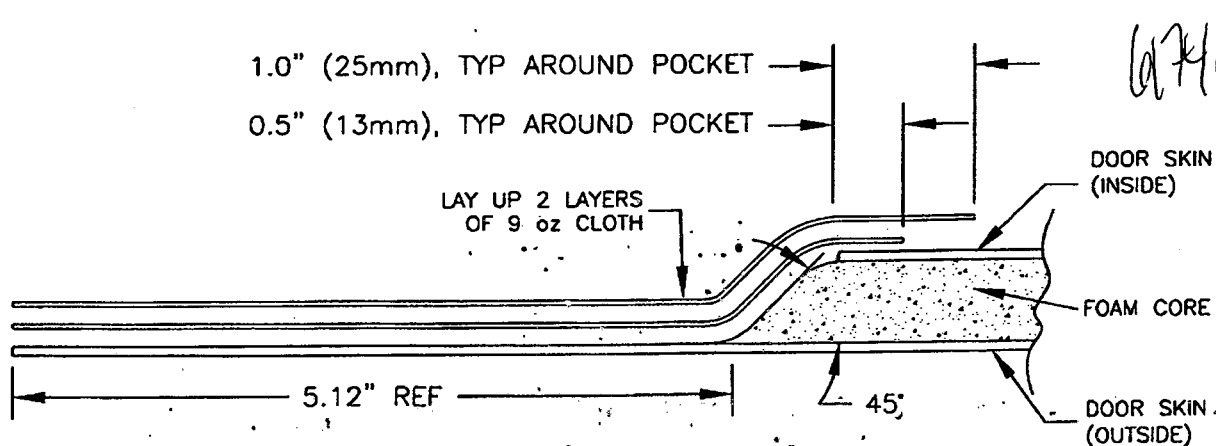
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**FIGURE 2: TRIMMING FOAM CORE  
(VIEW LOOKING AT INSIDE OF DOOR)  
(-041 SHOWN, -042/-043 SIMILAR)**



**SECTION A-A**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

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